

Date: Tuesday, 2/26/2008 8:02:10 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : STRAP  
 Job Number : 37631  
 Estimate Number : 10729  
 P.O. Number :  
 This Issue : 2/26/2008 S.O. No. :  
 Prsht Rev. : NC Part Number : D23245  
 First Issue : / / Type : SMALL /MED FAB Drawing Number : D2324 REV C  
 Drawing Revision : C  
 Previous Run : 36749B Material :  
 Due Date : 3/17/2008 Qty: 50 Um: Each  
 Written By :  
 Checked & Approved By : AF 08 02 26  
 Comment : Est. E 03.02.28 Reformat; Incorporated D2324-3 & D2324-5 K  
 J/RF

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304S16GA 304/316 .063 Sheet



Comment: Qty.: 0.0184 sf(s)/Unit Total : 0.9200 sf(s)  
 304/316 .063 Sheet 106860 B 8-3-4

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET  
 1-Cut as per Dwg D2324  
 Dwg Rev: C  
 Prog Rev: C

B 8-3-4

2-Deburr if necessary

E 08/03/06

49

51

58

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



B 8-3-4

Comment: DIMENSIONAL CHECK  
 Inspect dimensions per template D2324-5T1

4.0 QC8 SECOND CHECK



counts

Comment: SECOND CHECK

E 08/03/06

58

5.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
 Identify and Stock  
 Location:

8/3/6 54

54x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2324-5 PAR #: N/A Fault Category: Prod/Fab Pass' model Serial NCR: Yes No DQA: (1) Date: 08/03/07  
 QA: N/C Closed: HJ Date: 08/03/10

NCR: <u>37631</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/08/06	# 80	two parts scrap End of the sheet. RC improper placement on the water jet	<i>[Signature]</i>	Scrap and Destroy and Replk Qty (12)	<i>[Signature]</i> 8/3/06	<i>[Signature]</i> 08/08/06	<i>[Signature]</i>	<i>[Signature]</i> 08/08/06

NOTE: Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRAP

Job Number: 37631

Part Number: D23245

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



(54)

Comment: FINAL INSPECTION/W/O RELEASE

2008/03/07

Job Completion



2008/3/07

(54)

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

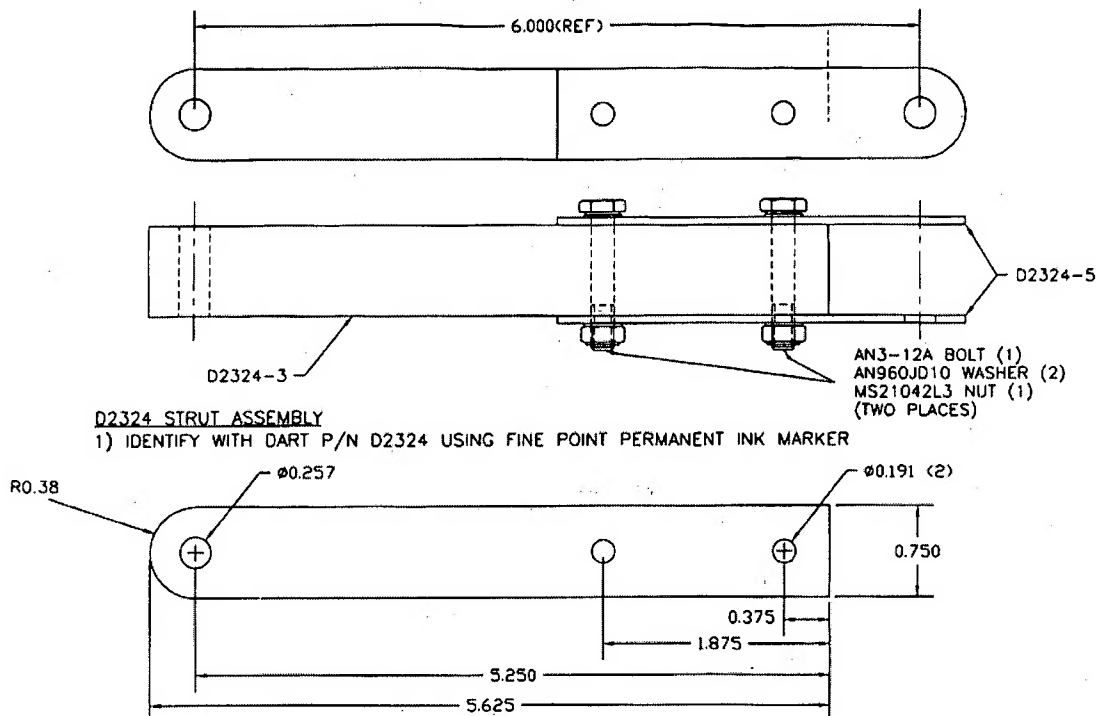
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

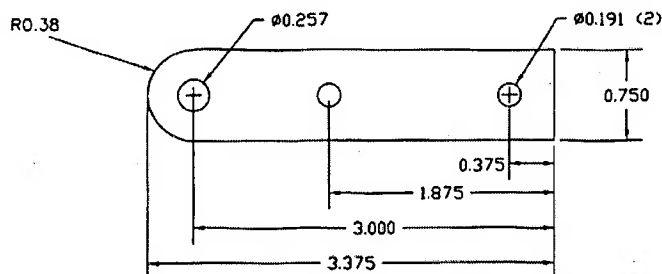


**DART**

DESIGN	DRAWN BY	DART AEROSPACE LTD	
B WILLIAMS	PH	VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO.	REV. C
		D2324	SHEET 1 OF 1
DATE		TITLE	SCALE
04.12.14		STRUT	
A	94.11.08	NEW ISSUE	
B	96.05.07	UPDATE MATERIALS	
C	04.12.14	UPDATE NOTES	

**RELEASED**04.12.16 *[Signature]***D2324-3**

- 1) MATERIAL: 6061-T6/T651 BAR (QQ-A-200/8) 0.75 X 0.75  
(REF DART SPEC. M6061T6B0.750X00.750)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



UNCO  
R'B  
COPY  
NOTICE  
WORK ORDER  
N.I. 37631